

## Work Order ID 61247



Page 1

August 11, 2010 11:50:58 AM

Item ID:	D3764-1	Accept		Setup	Start				
Revision ID:				Stop					
Item Name:	Back Leg Fitting								
Start Date:	8/11/10	Start Qty: 6.00		Cust Item ID:					
Required Date:	8/25/10	Req'd Qty: 6.00		Customer:					
Reference:									
Approvals:	Process Plan: <u>CZ</u>	Date: <u>10/8/11</u>	Tooling:	Date:	Run	Start			
	QC:	Date:	SPC (Y/N):	Date:	Stop				
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3764	Rev B								
100 	BAND SAW Bandsaw	0.00							
	Memo	0.00	<u>b.a</u>	<u>10/08/19</u>		<u>6</u>	<u>Ø</u>		
	Cut blank 2.95" long								
110 	HAAS CNC VERTICAL MACHINING #1 HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo	0.00	<u>10/08/21</u>			<u>6</u>	<u>J</u>		
	1- Mill as per Folio FA741 Rev: <u>AK</u> & Dwg D3764Rev: <u>R</u> <input type="checkbox"/> 2-Deburr per dwg D3764								
120 	QC2- Inspect parts off machine FAI/FAIB QC	0.00	<u>10/08/21</u>			<u>6</u>	<u>S</u>		
Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61247**

Page 2

August 11, 2010 11:50:58 AM

Item ID: D3764-1

Accept



Setup

Start



Revision ID:

Item Name: Back Leg Fitting

Stop



Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC8- Inspect parts - second check

0.00

DJP 10/08/22

6 ✓

QC

Memo

0.00

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

DJM 10/08/23

6x ✓

HandFinish

Memo

0.00

Hand Finishing

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

6x - BK 10-8-23.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61247**

Page 3

August 11, 2010 11:50:58 AM

Item ID: D3764-1

Accept



Setup Start



Revision ID:

Item Name: Back Leg Fitting

Stop



Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

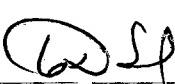


Identify as per dwg &amp; Stock Location

951A

0.00

17824



Packaging

Memo

0.00

Packaging

170



QC21- Final Inspection - Work Order Release

0.00

10/08/24 JG

QC

Memo

0.00

Quality Control

C21018124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

August 11, 2010 11:50:57 AM

Page 1

Work Order ID: 61247



Parent Item: D3764-1



Parent Item Name: Back Leg Fitting

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No			100	f	15.2863	0.25	1.578947			

6061-T6 Bar 1.50 x 2.00



Location	Loc Qty	Loc Code
MAT	12	
114608	12	
MAT10	3.2863	
110167	3.2863	

1.5789 ft H.A 10/08/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	61247
Description: Back Leg Fitting	Part Number:	D3764-1
Inspection Dwg: D3764 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10/08/20	Date:	10/08/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	 

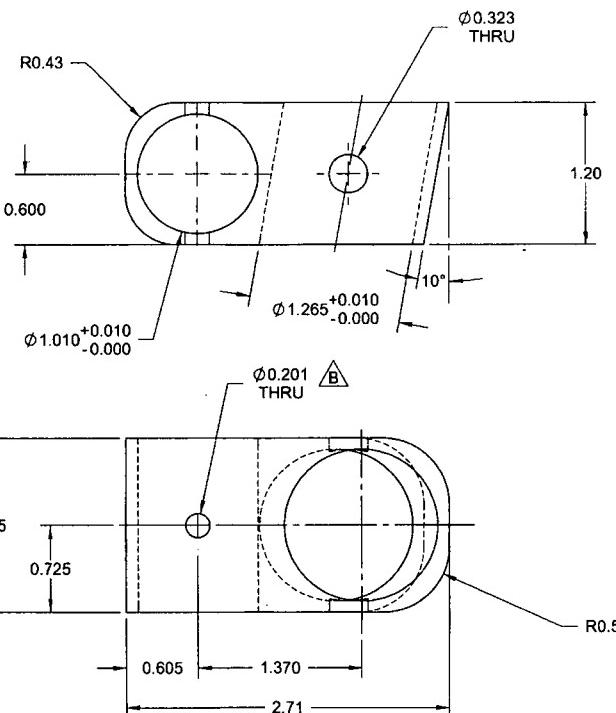
8 7 6 5 4 3 2 1

D

C

B

A

D3764-1 BACK LEG FITTING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 401247  
C21013111

## NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3764	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BACK LEG FITTING	NTS
DATE	08.06.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	